

**Work Order ID 66596**

Tuesday, February 22, 2011 1:28:07 PM



Page 1

Item ID: D3186-4

Accept



Setup Start



Revision ID:

Item Name: Spacepod Door, RH

Stop



Start Date: 2/22/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 1.00



Customer:

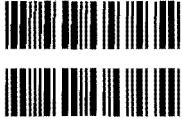
Reference:

Approvals: Process Plan:

Date: 11-02-22 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/  
Work Center ID**
**Operation  
Description**
**Set Up/  
Run Hours**

## Tool ID

## Tool #

**Plan  
Code**
**Accept  
Qty**
**Reject  
Qty**
**Reject  
Number**
**Insp.  
Stamp**
**Draw Nbr**
**Revision Nbr**

D3186

Rev E

100



Small Fab

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Trim door to fit spacepod before drill holes and cut out slots for latches as per  
dwg D3186 (D3186-4 detail)

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

customer  
ordered door  
only - no trim  
no holes  
S/O 104657

120



Memo

0.00

Packaging

Identify as per dwg &amp; Stock Location: 80104657 0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

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Page 2

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC21- Final Inspection - Work Order Release

0.00

0.00

QC

Quality Control

Memo

W4/14 JG

W4/14/14

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# Picklist Print

Tuesday, February 22, 2011 1:28:14 PM

Page 1

Work Order ID: 66596



Parent Item: D3186-4



Parent Item Name: Spacepod Door, RH

Start Date: 2/22/2011

Required Date: 2/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-01-11 EC

IPP rev.B revD 07.03.07 ec

IPP Rev:C

10-08-11 added trim door before drilling DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3186-2M  SPACEPOD DOOR RH		Manufactured	No		100		Each	0.0000	1	1		66593	

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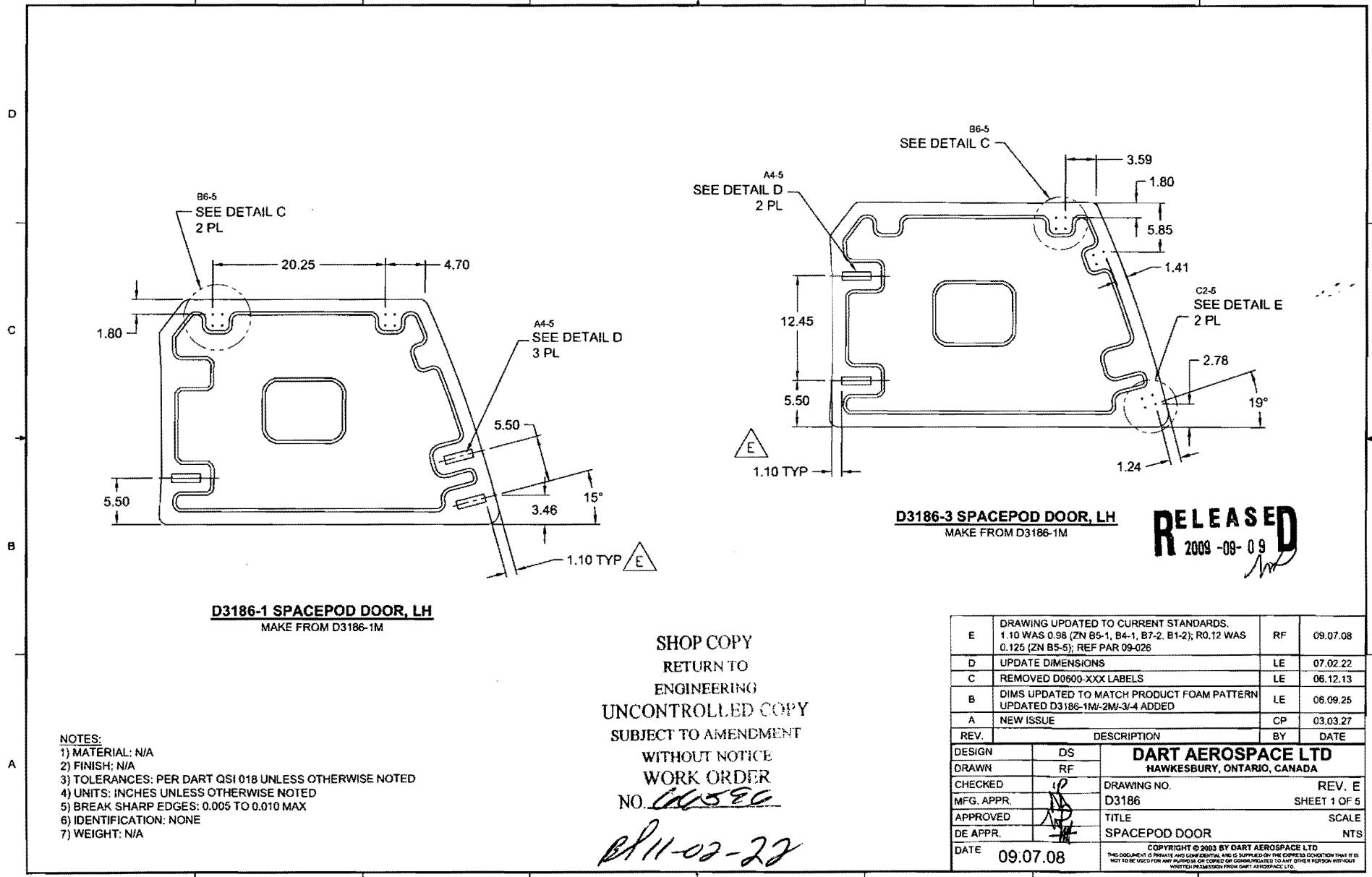
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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

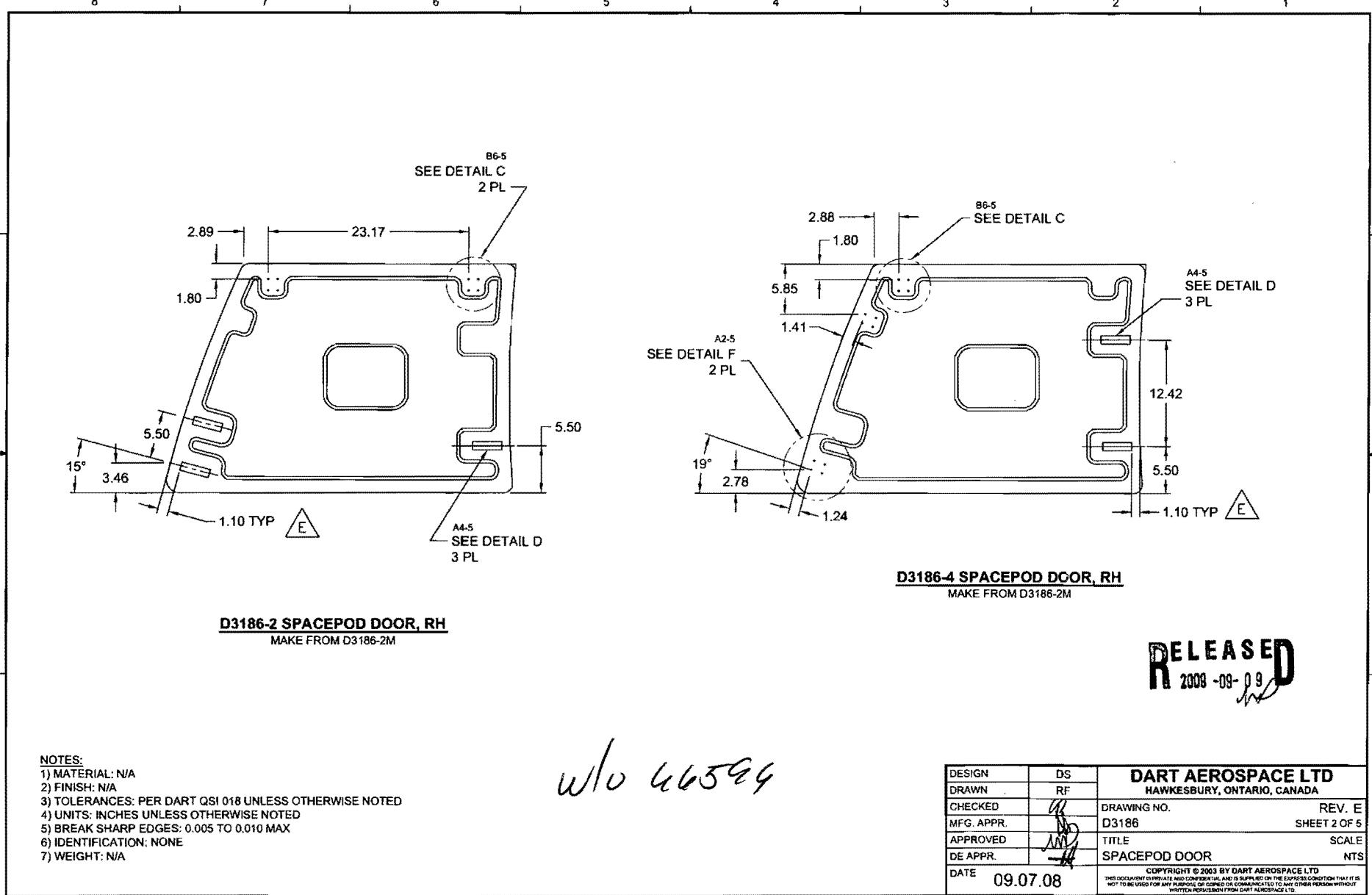
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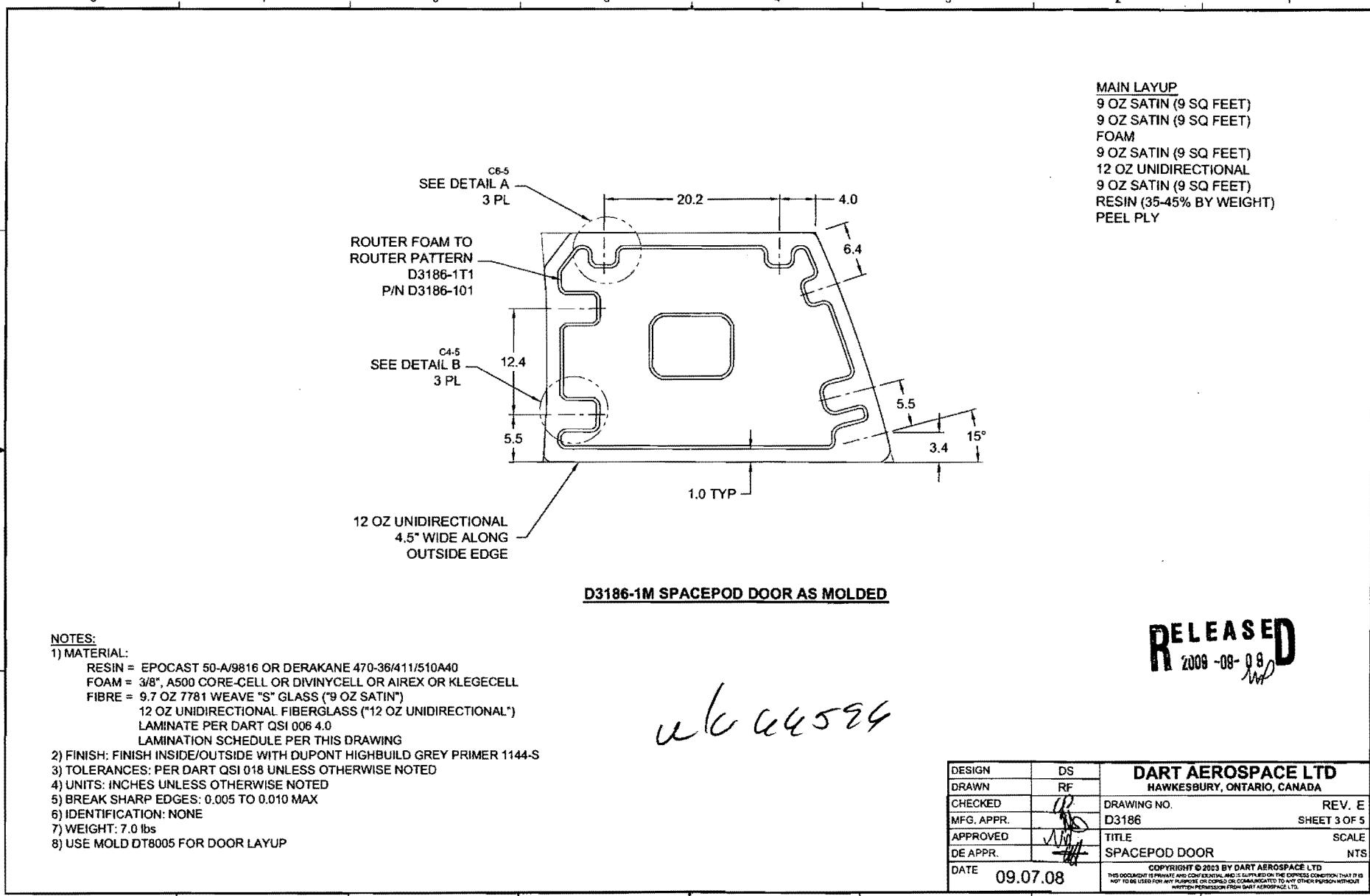
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8

7

6

5

4

3

2

1

D

D

C

C

B

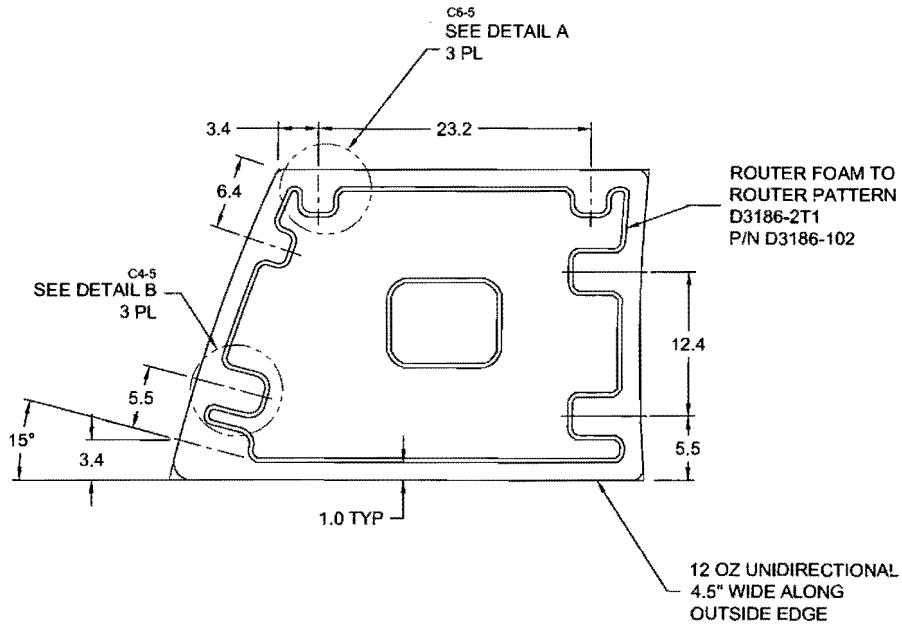
B

A

A

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)  
 9 OZ SATIN (9 SQ FEET)  
 FOAM  
 9 OZ SATIN (9 SQ FEET)  
 12 OZ UNIDIRECTIONAL  
 9 OZ SATIN (9 SQ FEET)  
 RESIN (35-45% BY WEIGHT)  
 PEEL PLY

NOTES:

- 1) MATERIAL:  
 RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
 FOAM = 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECCELL  
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
 LAMINATE PER DART QSI 006 4.0  
 LAMINATION SCHEDULE PER THIS DRAWING
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.0 lbs
- 8) USE MOLD DT8006 FOR DOOR LAYUP

u6 46590

D3186-2M SPACEPOD DOOR AS MOLDED

RELEASED  
2008-09-09  
M

8

7

6

5

4

3

2

1

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>✓</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>✓</i>	D3186	SHEET 4 OF 5
APPROVED	<i>✓</i>	TITLE	SCALE
DE APPR.	<i>✓</i>	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD	

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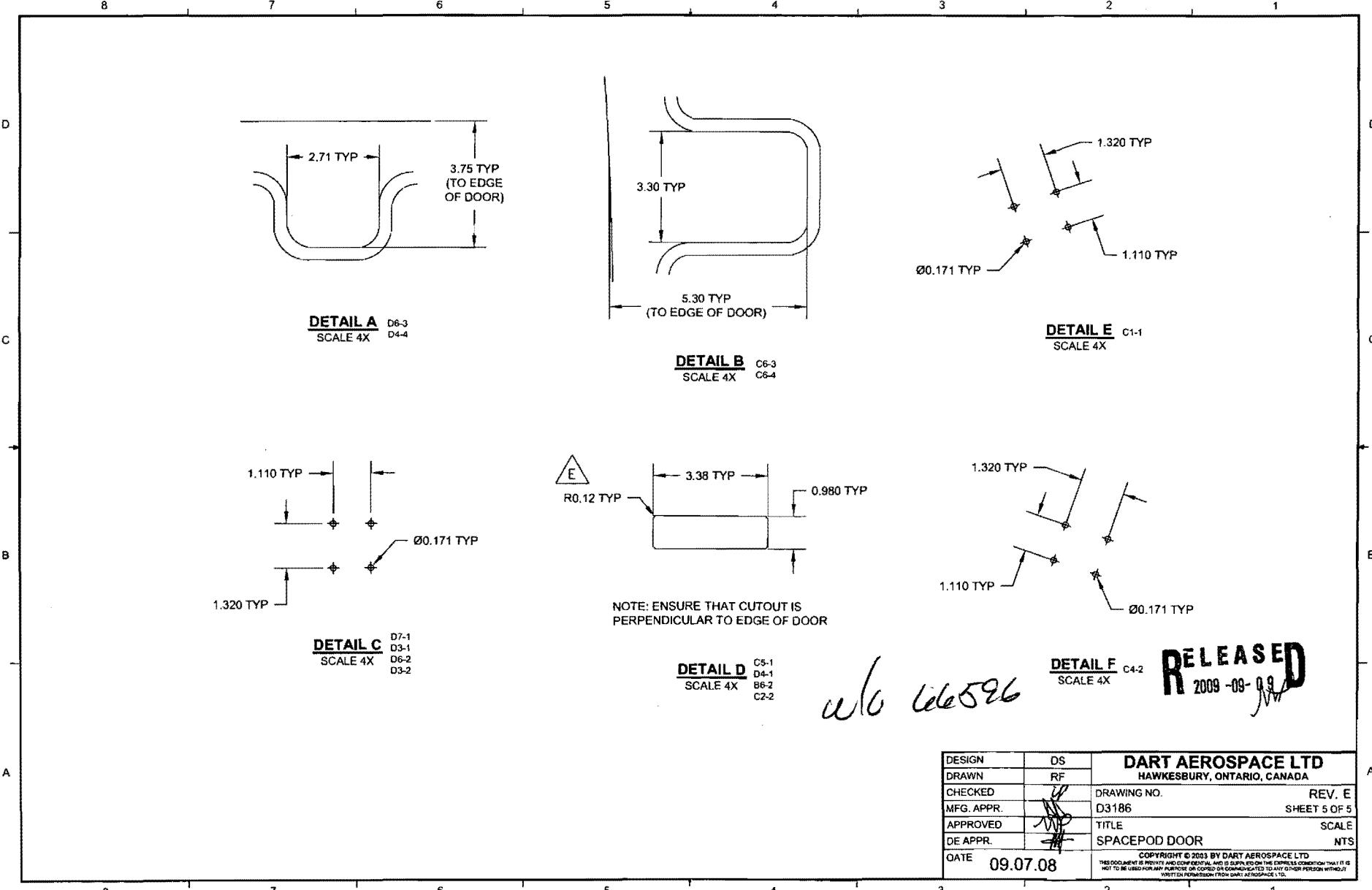
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<input checked="" type="checkbox"/>	DRAWING NO.	REV. E
MFG. APPR.	<input checked="" type="checkbox"/>	D3186	SHEET 5 OF 5
APPROVED	<input checked="" type="checkbox"/>	TITLE	SCALE
DE APPR.	<input checked="" type="checkbox"/>	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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